



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3500-1

Job Sheet 174614



Part No: D3500-1

Job Qty: 40 ea

Part Name: Saddle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/20/18

Job Tracking No:

Due Date: 6/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev:A New Issue 06-06-15 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		6/15/18	0.00	0.00	Start Up Machining-2		SBL 18/07/03
100	CNC Vertical Machining	40 pcs		6/19/18	0.15	50.00	HAAS1-3		IL 18-7-9
120	QC	40 pcs		6/19/18	0.00	0.00	QC8		MM 18/07/10
130	HandFinish	40 pcs		6/19/18	0.00	1.29	HandFinish1		SA 18-07-17
140	Powdercoat	40 pcs		6/20/18	0.00	1.21	Powdercoat1		IL 18-7-18
150	QC	40 pcs		6/20/18	0.00	0.00	QC3		JUL 24 2018
160	Packaging	40 pcs		6/20/18	0.00	0.00	Packaging3-1	St 406 90	21 JUL 24 2018
170	QC21-SA	40 Ea		6/20/18	0.00	0.00	QC21		

Part Op 100 - Program Batch No 508871 Double check by: MM 1-Machine Step No 1 per Folio FA641 and inspect per Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA641 and inspect p

140 - START TIME: 8:35 O.T. 3:00 FINISH: 9:05 M138839

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6102-013	Saddle Billet	40 Ea (1 ea)	90-Start up Operation	F164014 + F164406 + F165019 + F165299

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6102-013	40	46	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle	1.125Inches + 0.020 - 0.000	1.145 1.125	Radius	
2	Saddle	0.490Inches + 0.020 - 0.000	0.510 0.490	Radius	
3	Saddle	0.615Inches + 0.020 - 0.000	0.635 0.615		
4	Saddle	0.240Inches + 0.020 - 0.000	0.260 0.240		
5	Saddle	1.810Inches + 0.020 - 0.000	1.830 1.810		

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermofforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	
--	--	--	--	--

Date: _____	Step #: _____	QTY Effective: _____	MRB (QS1042) Approval
-------------	---------------	----------------------	-----------------------

Description Work Order Deviation	Disposition	Completed By
----------------------------------	-------------	--------------

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 07/03/18

QC / QA Coordinator
 Approval

Lead hand / Supervisor
 Approval Verification

Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pre ☐ Ber ☐ Cen ☐ Crai ☐ Crin ☐ Cuff ☐ Cru: ☐ Heal ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Instructions Incomplete/Unclear ☐ Drill Holes ☐	Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Mistread ☐ Turning Sequence ☐
--	--	--	--	--	--

6	Saddle	0.240Inches	+ 0.020 - 0.000	0.260 0.240	
7	Saddle	0.140Inches	+ 0.020 - 0.000	0.160 0.140	
8	Saddle	0.140Inches	+ 0.020 - 0.000	0.160 0.140	
9	Saddle	0.140Inches	+ 0.020 - 0.000	0.160 0.140	
10	Saddle	0.483Inches	+ 0.007 - 0.000	0.490 0.483	
11	Saddle	1.175Inches	+ 0.010 - 0.000	1.185 1.175	
12	Saddle	3.145Inches	+ 0.010 - 0.000	3.155 3.145	
13	Saddle	1.175Inches	+ 0.010 - 0.000	1.185 1.175	
14	Saddle	0.365Inches	+ 0.020 - 0.000	0.385 0.365	
15	Saddle	0.490Inches	+ 0.020 - 0.000	0.510 0.490	
16	Saddle	0.515Inches	+ 0.020 - 0.000	0.535 0.515	Radius
17	Saddle	1.575Inches	+ 0.020 - 0.000	1.595 1.575	Radius
18	Saddle	0.240Inches	+ 0.020 - 0.000	0.260 0.240	
19	Saddle	0.490Inches	+ 0.020 - 0.000	0.510 0.490	
20	Saddle	3.590Inches	+ 0.060 - 0.000	3.650 3.590	
21	Saddle	0.315Inches	+ 0.007 - 0.000	0.322 0.315	
22	Saddle	0.256Inches	+ 0.006 - 0.000	0.262 0.256	
23	Saddle	6.500Inches	+ 0.020 - 0.000	6.520 6.500	
24	Saddle	5.990Inches	+ 0.020 - 0.000	6.010 5.990	
25	Saddle	2.820Inches	+ 0.010 - 0.000	2.830 2.820	
26	Saddle	2.495Inches	+ 0.010 - 0.000	2.505 2.495	
27	Saddle	2.245Inches	+ 0.010 - 0.000	2.255 2.245	
28	Saddle	1.120Inches	+ 0.010 - 0.000	1.130 1.120	
29	Saddle	0.540Inches	+ 0.020 - 0.000	0.560 0.540	
30	Saddle	0.793Inches	+ 0.010 - 0.000	0.803 0.793	
31	Saddle	0.240Inches	+ 0.020 - 0.000	0.260 0.240	Radius
32	Saddle	0.040Inches	+ 0.020 - 0.000	0.060 0.040	
33	Saddle	0.100Inches	+ 0.020 - 0.000	0.120 0.100	

DART AEROSPACE LTD		Work Order: 174 C614
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.377	.375	.377	.378	.377
F	0.490	0.510		.500	.500	.500	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.575	1.580	1.580	1.580	1.585
J	0.240	0.260		.256	.256	.250	.251	.250
K	0.490	0.510		.498	.500	.500	.500	.500
L	3.590	3.650		3.620	3.617	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.002
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.552	.551	.552	.551	.552
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.047	.050	.050
Y	0.100	0.120		.101	.103	.104	.103	.105
AA	R1.125	R1.145		1.125	1.130	1.125	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.625	.630	.625	.627	.625
AD	0.240	0.260		.256	.258	.253	.253	.253
AE	1.810	1.830		1.820	1.820	1.822	1.820	1.820
AF	0.240	0.260		.254	.250	.251	.251	.251
AG	0.140	0.160		.151	.151	.151	.151	.151
AH	0.140	0.160		.154	.154	.151	.151	.150
AI	0.140	0.160		.154	.152	.148	.148	.148

DAS Accept/Reject

Measured by: 57	Date: 18/07/03
Audited by: 9-89	Date: 18/07/29
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 174 614	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6 1	7 2	8 3	9 4	10 5
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.378	.375	.377	.378
F	0.490	0.510		.500	.500	.500	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.250	.251	.251	.250	.250
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257
O	6.500	6.520		6.510	6.510	6.510	6.509	6.510
P	5.990	6.010		6.000	6.002	6.000	6.002	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.553	.553	.552	.551	.552
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.105	.103	.105	.103	.105
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.625	.627	.625	.628	.628
AD	0.240	0.260		.253	.252	.253	.253	.254
AE	1.810	1.830		1.820	1.820	1.822	1.822	1.821
AF	0.240	0.260		.251	.251	.251	.251	.251
AG	0.140	0.160		.151	.152	.151	.151	.151
AH	0.140	0.160		.151	.150	.152	.151	.252
AI	0.140	0.160		.147	.148	.146	.147	.147

DAS Accept/Reject

Measured by: 57	Date: 18/07/04
Audited by: mm	Date: 18/07/14
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 174614	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
A	0.483	0.490		.484	.484	0.484	0.484	0.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.375	0.375	0.375	0.375
F	0.490	0.510		.500	.500	0.500	0.500	0.500
H	R0.515	R0.535		.525	.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.250	0.250	0.252	0.252	.250
K	0.490	0.510		.500	.500	0.500	0.500	0.500
L	3.590	3.650		3.62	3.62	3.62	3.62	3.62
M	0.315	0.322		.316	.316	0.316	0.316	0.316
N	0.256	0.262		.257	.257	0.257	0.257	0.257
O	6.500	6.520		6.510	6.510	6.511	6.511	6.511
P	5.990	6.010		6.000	6.000	6.008	6.008	6.008
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.251
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.552	0.554	0.551	0.551	0.551
V	0.793	0.803		.798	.798	0.798	0.798	0.798
W	R.240	R.260		.250	.250	0.250	0.250	0.250
X	0.040	0.060		.050	.050	0.048	0.048	0.046
Y	0.100	0.120		.104	.100	0.100	0.100	0.100
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	R0.500	R0.500	R0.500
AC	0.615	0.635		.627	.627	0.627	0.627	0.627
AD	0.240	0.260		.252	0.251	0.251	0.254	0.255
AE	1.810	1.830		1.820	1.820	1.822	1.823	1.823
AF	0.240	0.260		.250	.251	0.250	0.251	0.251
AG	0.140	0.160		.151	.151	0.151	0.151	0.153
AH	0.140	0.160		.151	0.151	0.152	0.150	.150
AI	0.140	0.160		.148	0.148	0.149	0.147	0.146
Accept/Reject								

Measured by:	Date:
---------------------	--------------

Audited by:	Date:
--------------------	--------------

Preliminary Approval:	Date:
------------------------------	--------------

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 174614	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	20
A	0.483	0.490		0.484	0.484	0.484	0.484	0.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.501	0.502	0.502	0.501	0.501
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.595	1.595	1.595	1.595	1.595
J	0.240	0.260		0.250	0.250	0.250	0.251	0.250
K	0.490	0.510		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		0.316	0.316	0.316	0.316	0.316
N	0.256	0.262		0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.510	6.511	6.511	6.511	6.511
P	5.990	6.010		6.007	6.007	6.006	6.006	6.006
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.501	2.502	2.500	2.500	2.500
S	2.245	2.255		2.252	2.254	2.253	2.253	2.253
T	1.120	1.130		1.126	1.125	1.125	1.125	1.125
U	0.540	0.560		0.553	0.552	0.554	0.554	0.554
V	0.793	0.803		0.793	0.793	0.793	0.793	0.793
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.048	0.048	0.055	0.050	0.058
Y	0.100	0.120		0.100	0.102	0.104	0.102	
AA	R1.125	R1.145		R1.135	R1.135	R1.135	R1.135	R1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.252	0.253	0.253	0.254	0.252
AE	1.810	1.830		1.821	1.821	1.821	1.820	1.820
AF	0.240	0.260		0.253	0.248	0.251	0.2495	0.252
AG	0.140	0.160		0.151	0.150	0.151	0.147	0.150
AH	0.140	0.160		0.152	0.151	0.151	0.153	0.151
AI	0.140	0.160		0.151	0.148	0.148	0.148	0.145

Accept/Reject

Measured by:	Date:
Audited by:	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD		Work Order: 174 614
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	25
A	0.483	0.490		0.484	0.484	0.484	0.484	0.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.501	0.501	0.501	0.501	0.501
H	R0.515	R0.535		R0.525	R0.525	R0.525	R0.525	R0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		R1.595	R1.595	R1.595	R1.595	R1.595
J	0.240	0.260		0.253	0.250	0.250	0.250	0.250
K	0.490	0.510		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		0.316	0.316	0.316	0.316	0.316
N	0.256	0.262		0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.510	6.512	6.512	6.512	6.512
P	5.990	6.010		6.007	6.007	6.007	6.007	6.007
Q	2.820	2.830		2.820	2.820	2.820	2.820	2.820
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.540	0.540	0.540	0.540	0.540
V	0.793	0.803		0.793	0.793	0.793	0.793	0.793
W	R.240	R.260		R0.250	R0.250	R0.250	R0.250	R0.250
X	0.040	0.060		0.050	0.050	0.049	0.048	0.047
Y	0.100	0.120		0.110	0.110	0.102	0.102	0.102
AA	R1.125	R1.145		R1.125	R1.125	R1.125	R1.125	R1.125
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.250	0.250	0.250	0.251	0.252
AE	1.810	1.830		1.820	1.820	1.820	1.821	1.820
AF	0.240	0.260		0.253	0.251	0.250	0.250	0.250
AG	0.140	0.160		0.153	0.151	0.150	0.151	0.151
AH	0.140	0.160		0.151	0.150	0.150	0.152	0.152
AI	0.140	0.160		0.147	0.144	0.150	0.147	0.148

Accept/Reject

Measured by:	Date:
Audited by:	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 174 6014	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				26	27	28	29	30
A	0.483	0.490		0.484	0.484	0.484	0.484	0.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.376	0.376	0.378	0.379	0.379
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.586	1.585	1.585	1.585	1.585
J	0.240	0.260		0.249	0.249	0.249	0.249	0.249
K	0.490	0.510		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		0.316	0.316	0.316	0.316	0.316
N	0.256	0.262		0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.512	6.511	6.511	6.511	6.511
P	5.990	6.010		6.003	6.002	6.002	6.002	6.002
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.549	0.547	0.549	0.548	0.549
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.103	0.101	0.104	0.104	0.103
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.628	0.628	0.628	0.628	0.628
AD	0.240	0.260		0.253	0.254	0.253	0.253	0.252
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.821
AF	0.240	0.260		0.249	0.248	0.249	0.249	0.249
AG	0.140	0.160		0.152	0.153	0.151	0.151	0.151
AH	0.140	0.160		0.151	0.152	0.152	0.152	0.151
AI	0.140	0.160		0.151	0.152	0.151	0.151	0.151
Accept/Reject								

Measured by:		Date:	
Audited by:		Date:	
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 174 6014	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				3 1	3 2	3 3	3 4	3 5
A	0.483	0.490		0.484	0.484	0.484	0.484	0.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.378	0.378	0.378	0.378	0.378
F	0.490	0.510		0.500	0.499	0.499	0.500	0.499
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		0.252	0.249	0.248	0.250	0.251
K	0.490	0.510		0.501	0.500	0.500	0.500	0.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		0.316	0.316	0.316	0.316	0.316
N	0.256	0.262		0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.511	6.511	6.511	6.511	6.511
P	5.990	6.010		6.002	6.002	6.002	6.002	6.002
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.547	0.547	0.548	0.554	0.553
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.102	0.103	0.100	0.100	0.100
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.630	0.630	0.632	0.630	0.630
AD	0.240	0.260		0.254	0.254	0.253	0.253	0.253
AE	1.810	1.830		1.821	1.821	1.822	1.821	1.819
AF	0.240	0.260		0.248	0.250	0.250	0.249	0.248
AG	0.140	0.160		0.151	0.152	0.151	0.151	0.150
AH	0.140	0.160		0.150	0.151	0.150	0.151	0.151
AI	0.140	0.160		0.151	0.151	0.151	0.149	0.149

Accept/Reject

Measured by: JL	Date: 18-7-9
Audited by:	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD		Work Order: 174 664
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				136	237	338	439	540
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.378	.378	.378	.378	.378
F	0.490	0.510		.499	.499	.500	.499	.498
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.250	.250	.250	.250	.250
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.004	6.003	6.004	6.004	6.004
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.550	.550	.550	.550	.550
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.100	.100	.100	.100	.100
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.630	.630	.630	.630	.630
AD	0.240	0.260		.254	.254	.254	.253	.254
AE	1.810	1.830		1.821	1.821	1.821	1.821	1.821
AF	0.240	0.260		.249	.249	.249	.249	.249
AG	0.140	0.160		.149	.150	.150	.149	.149
AH	0.140	0.160		.151	.152	.152	.151	.151
AI	0.140	0.160		.150	.151	.151	.151	.150
Accept/Reject								

Measured by: XL	Date: 18-7-9
Audited by:	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	